

**Work Order ID 57880**

Monday, April 19, 2010 3:33:46 PM

Page 1

Item ID: D350-588-041

Accept

Revision ID:

Item Name: Aft Door Assembly

Start Date: 4/19/2010 Start Qty: 1.00

Required Date: 4/26/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: CL Date: 10/4/20 Tooling:

QC: Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2445/D350-588	Rev D/D
----------------	---------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

5/10/06/09

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11710  
Description: D2445 Baggage Door  
Supplier: Delastek  
Ship to Delastek (1) D0588-041 label  
Certification of Conformity and process sheet from Delastek is required.

CL BS 10-4-2010-4-20  
(1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57880**

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Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Packaging

Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Memo

0.00

Ensure Certificate of Conformity &amp; Process Sheet are attached

*Run/22 (1)*

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Inspect as per Dwg D2445.  
Audit process sheet.*8/10/05/25*  
*8/10/06/03**PTO →*  
*(H)*  
*(H)*

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00





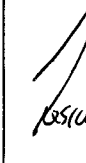

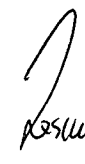


Assemble all of the above parts as per Dwg D350-588

*8/10/06-03*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-588-041 PAR #: \_\_\_\_\_ Fault Category: Supplier NCR: Yes No DQA: \_\_\_\_\_ Date: 05-31  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: 10/06/14

NCR: <u>57880</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/5/13 Be	# 130 #	Found at inspection that the hable had the wrong B# printed on it (identification label) P.C. Done at Delastick Salplus		- inform Delastick and find out why this happened attach communication. - prepare surface as per QSR037 where label goes	CT 10/5/13  BT 0606	8 606603  8 606603		
				<del>Prepare surface as per QSR037 where label goes</del> install actual decal D0588-041 w/ correct B# + cover w/ one layer 9oz cloth using epocast 50-A1 epocast 50-A1 B 11166	BT 10-06 -02	8 606603		
				9oz cloth B 11166 re prime as per QSR 005	BT 10-06 -02	8 606603		

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



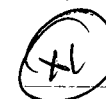
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10606103



Memo

0.00

155



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-6-95

160



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S 10606109



Memo

0.00

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location:

43

0.00

REV D

10-6-95

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/14  
MF  
10-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC



IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN526C832R9		Purchased	No			140	Each	418.0000	8.0000			
												
Screw											ET 10-06-03	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327

418

113845

18

114341

200

114405

200

AN960JD10

Purchased No

140

Each

0.0000

2.0000

  
Washer NAS1149003635

m 114292

ET 10-06-03

AN960JD8


Purchased No

140

Each

0.0000

8.0000

  
Washer NAS1149003635

m 114740

ET 10-06-03

D2143

Manufactured No

140

Each

35.0000

1.0000

  
Hinge Bracket

ET 10-06-03

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST198

35

37739

9

55323

26

xl

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC





IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2144	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 60.0000	Remaining 1.0000	Qty	Date	Status
											ET 10-06-03	
Hinge Bracket												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST198</div> <div>55061</div> <div>55179</div> <div>Loc Qty</div> <div>60</div> <div>8</div> <div>52</div> <div>Loc Code</div>												
D2463		Manufactured	No			140	f	512.5036	7.2500			
											ET 10-06-03	
Seal												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST404</div> <div>43841</div> <div>50075</div> <div>55561</div> <div>Loc Qty</div> <div>512.5036</div> <div>3</div> <div>15.7536</div> <div>493.75</div> <div>Loc Code</div>												
(D2463-0870) cut (1) at 7.25"												
**** per kit****												

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC



IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2585	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 107.0000	Remaining 2.0000	Qty	Date	Status
												
Mounting Channel											IT 10-06-03	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST018

62

53798

2

55313

60

X 2

Main Warehouse

ST019

45

56524

45

D2586



Door Latch

Manufactured No

140

Each

85.0000

2.0000



IT 10-06-03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST204

85

55314

85

X 2

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Shop Packet Print

Page 3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC



IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2621	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 118.0000	Remaining 2.0000	Qty	Date	Status
												
Latch Plate, 350 Spacepod											25 10-06-03	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

118

46842

49

56526

69

x2

D2857-1



Hinge Bracket

Manufactured No

140

Each

38.0000

1.0000



25 10-06-03

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST026

38

55019

19

56529

19

x1

D2857-2



Hinge Bracket

Manufactured No

140

Each

48.0000

1.0000



25 10-06-03

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

48

55020

28

56530

20

x1

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC



IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			140	Each	667.0000	8.0000			
												
Nut										25	10-06-03	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

400

114330

400

x 8

Main Warehouse

ST301

267

114056

67

114227

200

MS21042L3



Nut

Purchased

No

140

Each

1,131.000 2.0000



45

10-06-03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1131

113537

147

113644

984

x 2

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-15		Purchased	No			140	Each	137.0000	2.0000			
												
Screw												

RT 10-06-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST292

137

112794

37

114056

100

AN526C1032R7

Purchased

No

155

Each

136.0000

2.0000

Screw

x2

10-6-95

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST328

136

113064

66

113749

20

114056

50

AN526C832R8

Purchased

No

155

Each

140.0000

8.0000

Screw

2

10-6-95

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327

140

113595

140

8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10	AS114003634	Purchased	No			155	Each	0.0000	2.0000			
Washer												
AN960JD8	AS1149028324	Purchased	No			155	Each	0.0000	16.0000			
Washer												
D2150		Manufactured	No			155	Each	70.0000	2.0000			
Packer Doubler, Hinge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST007

70

55016

16

55178

54

Manufactured No

155

Each

55.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST007

55

51407

17

55319

38

D2151

Packer Doubler, Hinge

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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10.03.29 verified by:EC


IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2153		Manufactured	No			155	Each	36.0000	1.0000			
												
Door Prop												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST272

36

48373

1

55324

35

Manufactured No

155

Each

28.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST007

28

44890

8

55325

20

D2154



Stud Bracket

Monday, April 19, 2010 3:33:46 PM

Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, April 19, 2010 3:33:46 PM

Page 9

Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC


IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2237		Manufactured	No			155	Each	95.0000	2.0000			
											10-6-95	
Striker Plate												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST009

40

57255

40

Main Warehouse

ST010

55

55006

6

55312

49

D2461

Manufactured No

155

f

393.5000 7.2500



Neoprene "D" Seal



10-6-95

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST402

393.5

39782

6.5

55054

387

(D2461-0870) cut (1) at 7.25"

\*\*\*\* per kit\*\*\*\*

D2589

Manufactured No

155

Each

0.0000 1.0000



Keys, Key Chain, 350 Hinge



BS8194 10-6-95

Monday, April 19, 2010 3:33:46 PM

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Page 9

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:46 PM

Page 10

Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC


IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2690-17		Manufactured	No			155	Each	8.0000	1.0000			
												
Cable												

BS7534 10-6-9 SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

8

56567

8

Manufactured No

155

Each

40:0000

1.0000



10-6-9 SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

40

45798

7

55062

12

56423

21

Manufactured No

155

Each

32.0000

1.0000



10-6-9 SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

32

55063

11

56048

21

D2858-1



Hinge Bracket

D2858-2



Hinge Bracket

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:46 PM

Page 11

Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DSI9414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ 1	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
FG-778150-550-ROL		Purchased	No			155	sf	2,302.000	1.0000			
7781 9oz Glass 50"x125yd												

X

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST404	2302	
108932	108	
111166	419	
113905	1775	

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased No

155 Each 6,848.000 12.0000

RIVET

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST316	6848	
104374	2848	
110398	4000	

MS20470AD4-5

Purchased No

155 Each 618.0000 18.0000

Rivet, Universal Head

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST319	618	
111916	618	

10-6-98

10-6-98

12

M114718 10-6-98

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:33:46 PM

Page 12

Work Order ID: 57880

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC


IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			155	Each	667.0000	10.0000			
												
Nut											16-6-8	S

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST300	400	
114330	400	
Main Warehouse		
ST301	267	
114056	67	
114227	200	

MS21042L3



Nut

Purchased No 155 Each 1,131.000 4.0000

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST300	1131	
113537	147	
113644	984	

114523

10-6-9 S

Monday, April 19, 2010 3:33:46 PM

Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 13

Monday, April 19, 2010 3:33:46 PM

Work Order ID: 57880



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-08-11		Purchased	No			155	Each	119.0000	2.0000	/		
Screw												

10-6-95

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST288	50	
114382	50	
Main Warehouse		
ST290	69	
111977	19	
113749	50	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

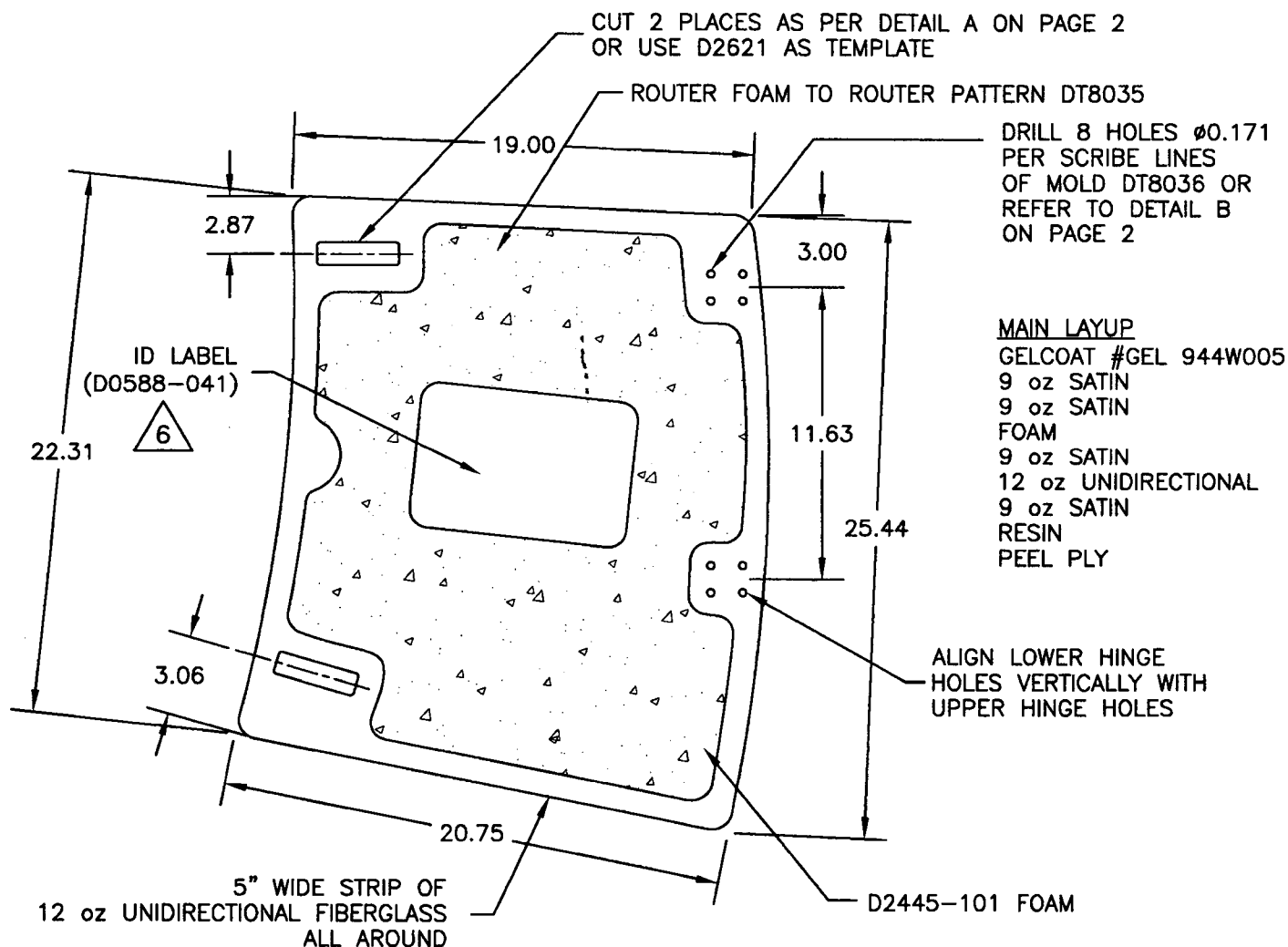
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

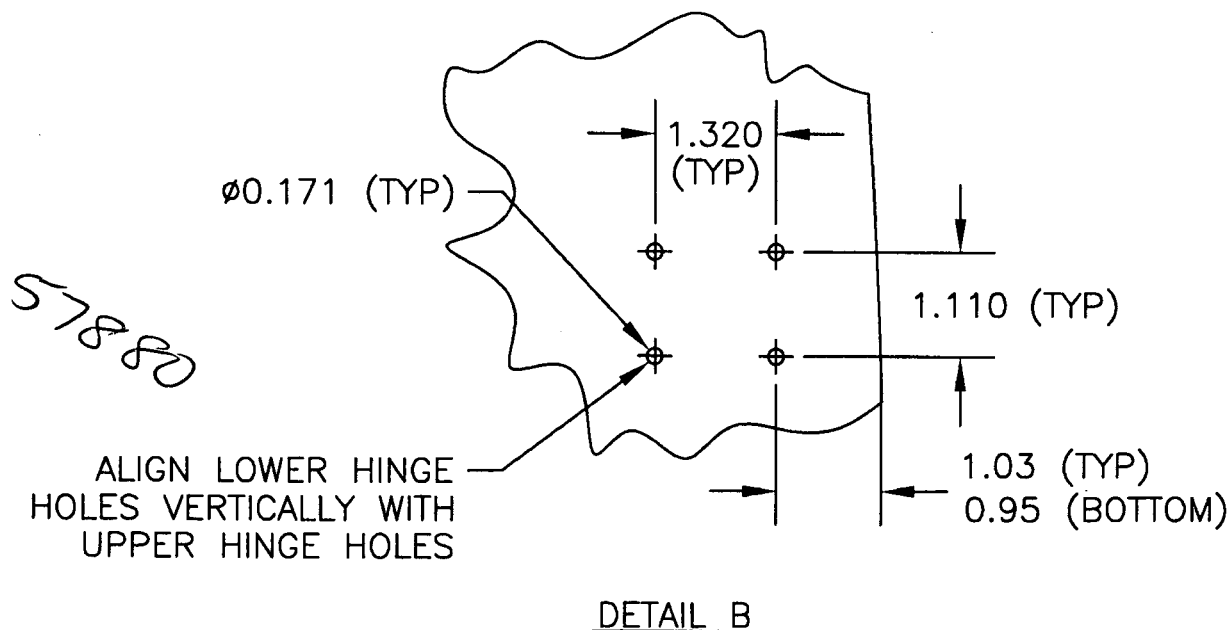
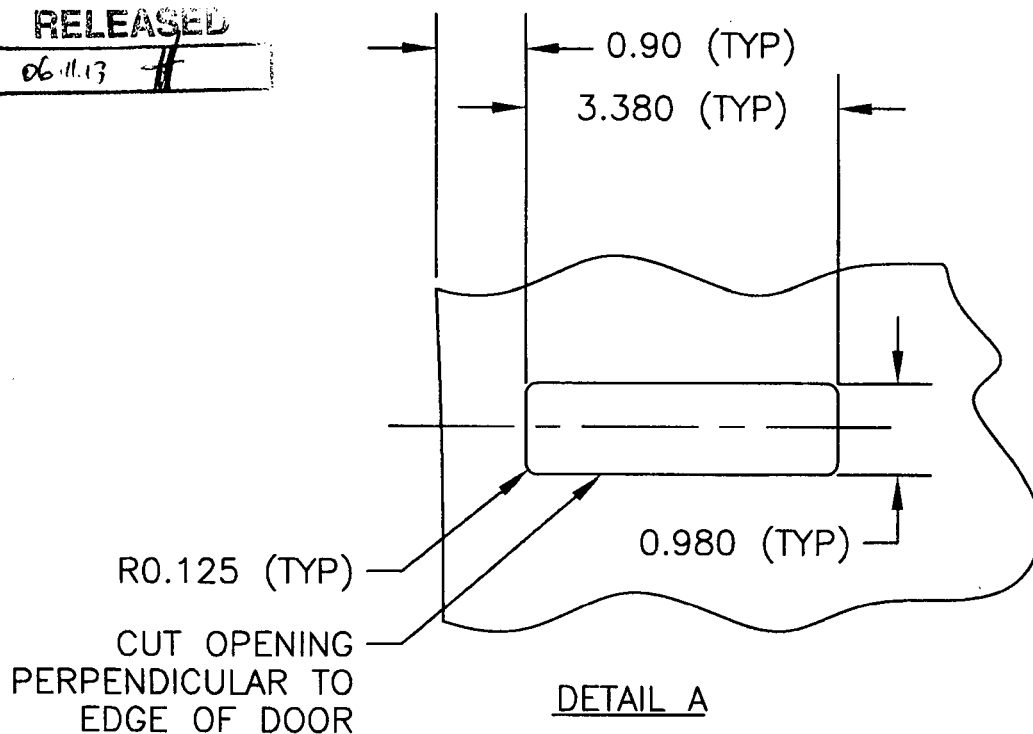
*CL10/4/20*  
*W10: 57880***Copyright © 1997 by DART AEROSPACE LTD**

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DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED  
06.11.13 *[Signature]*



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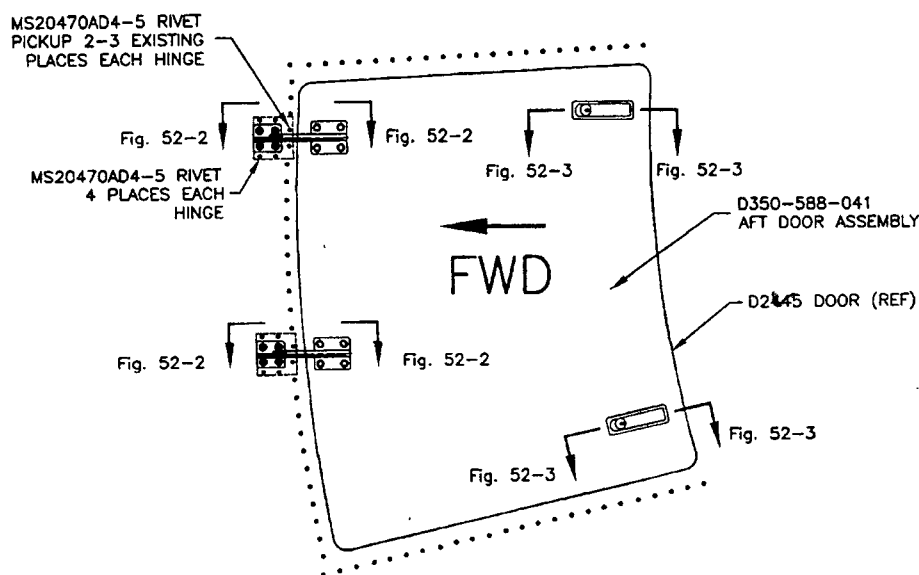


Figure 52-1: Baggage Door Outside View

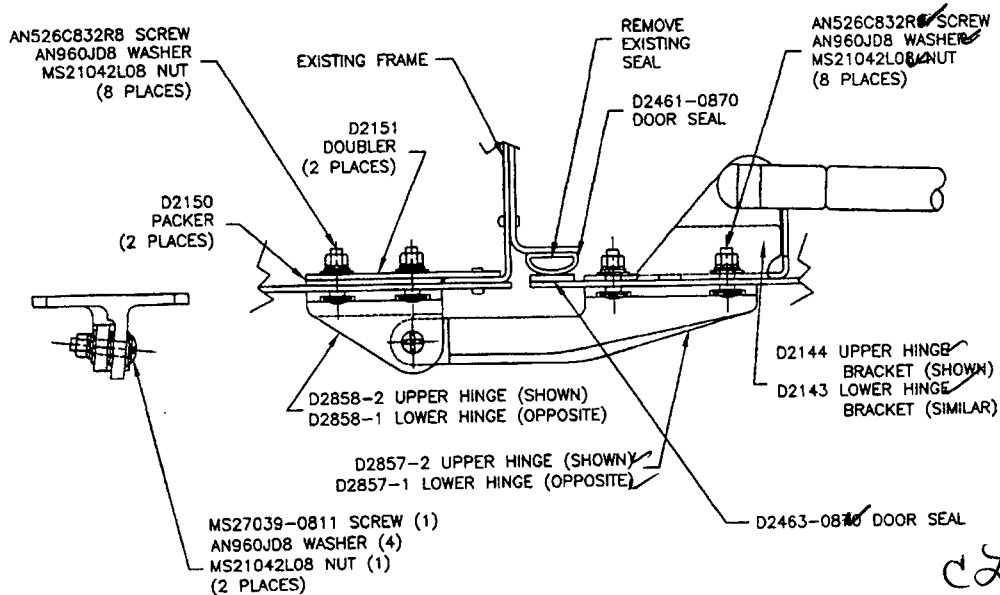
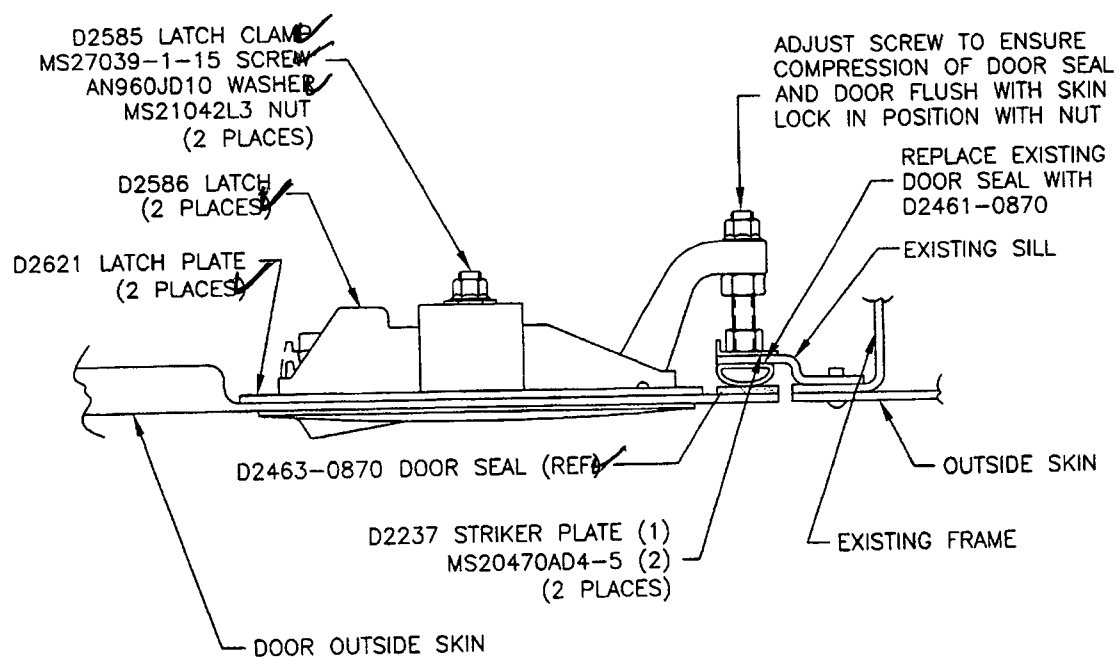


Figure 52-2: Hinge Detail

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57880

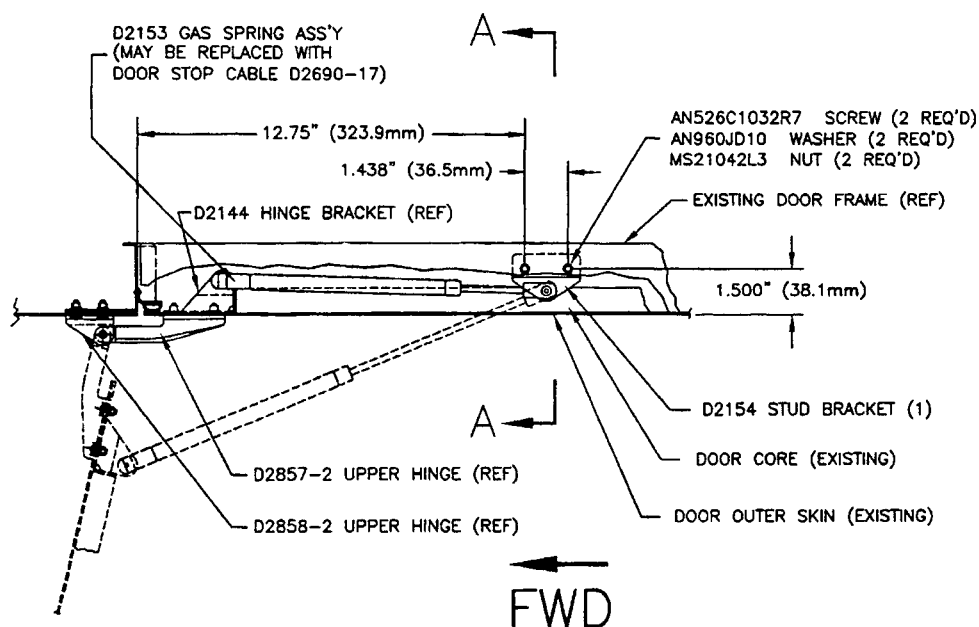
**Figure 52-3: Latch Section**

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SECTION A-A

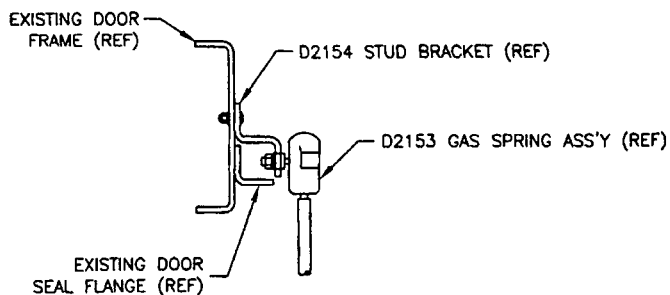


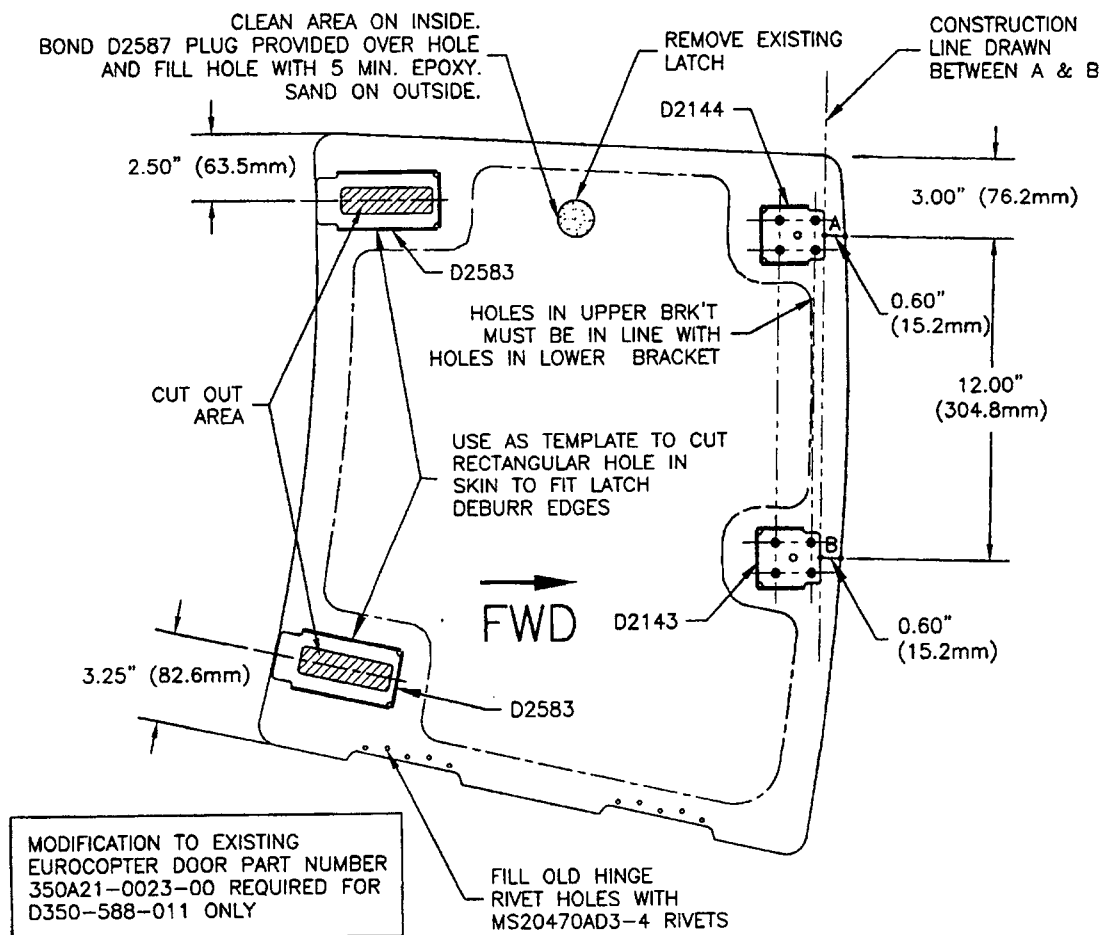
Figure 52-4: Gas Spring Installation

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57880

Figure 52-5: Baggage Door Inside View

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Revision: 0



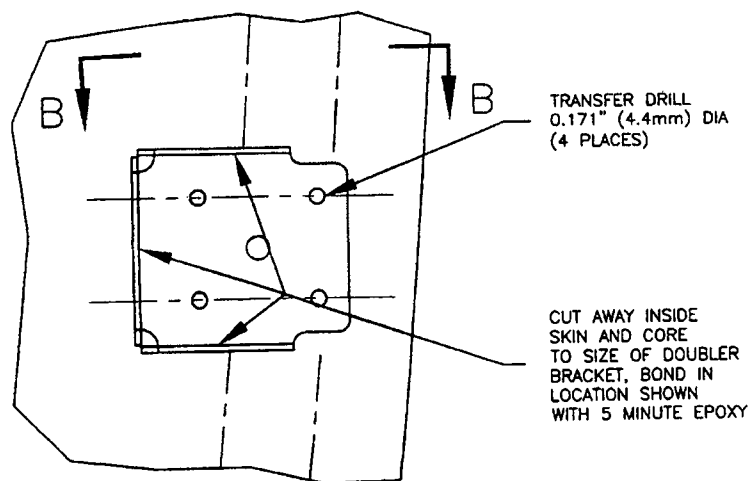
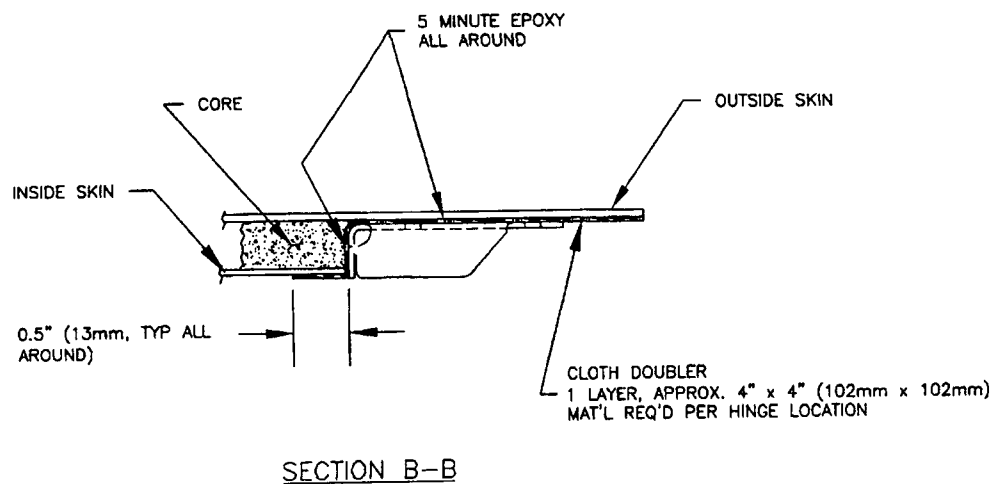


Figure 52-6: Typical Doubler Bracket Installation

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52-00-00



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33185
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
27/05/2010	20/04/2010	13866	Brigitte Golden	11710			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line #2 D350-588-041 Aft Baggage Door (D2445) B57880 U de M : Each Drawing N° : D2445 Rév.: D			
				No. lot 25942		Qté 1	
S1065128							

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Lundi, 2010-04-26 09:52:52  
Utilisateur: marc dubé

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 25942	Numéro Article	: DKC134-0013
Numéro Soumission	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2010-04-26 No. B.V. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Dûe	: 2010-05-03
Job précédente	:	Qté:	1 Udm: UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D2445		



Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
Rév.: 10 de DKC

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-27406-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0 AC0747 Acetone

Commentair Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 7-5-10 Sceau: Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

Date: Lundi, 2010-04-26 09:52:52  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 25942

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 7-5-10 Sceau:  Temps Début:        Temps Fin:       

8.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-26697-1

13.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

14.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Lundi, 2010-04-26 09:52:52

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25942

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 30-04-10 Heure Début: — Heure Fin: — Sceau:



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 7-5-10 Heure Début: — Heure Fin: — Sceau:



19.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 7-5-10 Heure Début: — Heure Fin: — Sceau:



20.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 7-5-10 Heure Début: — Heure Fin: — Sceau:



Curing début: 12:40 Curing Fin: 8:00

Date: Lundi, 2010-04-26 09:52:52  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 25942

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

22.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

23.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préprparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 5-5-10 Heure Début: — Heure Fin: — Sceau:  

24.0 AAC1611 Polybond B46F

Commentaire Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)  
Polybond B46F N° de Lot: 1-7089-1

25.0 DKC134-0029 Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Foam Core N° D2445-101 ( Pour AFT Baggage Door ) N° de Job: 43653

26.0 ASSEMBLAGE Assemblage mécanique



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 10-5-10 Heure Début: — Heure Fin: — Sceau:   

27.0 BAGGING Faire le bagging sur la pièce



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air embian pendant 2 heures minimum.

Date: 10-5-10 Heure Début: — Heure Fin: — Sceau:   

Curing Début: 2:45 Curing Fin: 4:10

Date: Lundi, 2010-04-26 09:52:52

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25942

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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28.0	AMB0286	Catalyst N° DDM-9
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Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

29.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

30.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11-5-10 Heure Début: — Heure Fin: — Sceau:

31.0	LAMINAGE	Faire le laminage
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 11-5-10 Heure Début: — Heure Fin: — Sceau:

32.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 11-5-10 Heure Début: — Heure Fin: — Sceau:

Curing Début: 12:50 Curing Fin: 8:00

Date: Lundi, 2010-04-26 09:52:52

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25942

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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33.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Set up: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 12-5-10 Heure Début:      Heure Fin:      Sceau: 


34.0	TRIMAGE	Trimage / Rivetage
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 12-5-10 Heure Début:      Heure Fin:      Sceau: 

35.0	AAC1605	Label N° D0588-041
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Label N° D0588-041 N° de Lot: 1-27436-1

36.0	AAC1609	Surface Veil
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Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)  
Surface Veil N° de Lot: N/A

37.0	AAC1220	Résine Mia-Poxy 100
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Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)  
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

38.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy
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Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-25679-2


39.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 13-5-10 Heure Début:      Heure Fin:      Sceau: 



Date: Lundi, 2010-04-26 09:52:53

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25942

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

40.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total : 0.025 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-7129-1

41.0 AAC1617 Durcisseur Polysoft #004079 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: ~~1-7129-1~~ N/A

42.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 13-5-10 Heure Début: — Heure Fin: — Sceau:



43.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26575-4

44.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26575-5

45.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 12/05/10 Sceau:



Quantité: 1 Date: 14/05/10 Sceau:



46.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 17-5-10 Heure Début: — Heure Fin: — Sceau:



47.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: Lundi, 2010-04-26 09:52:53  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 25942

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération:

Description :

Quantité: 1 Date: 17-05-10 Sceau:



## Chantal Lavoie

---

**From:** Nancy Carignan [ncarignan@delastek.com]  
**Sent:** June 2, 2010 5:03 PM  
**To:** 'Chantal Lavoie'  
**Subject:** RE: PO 11710

Hello Chantal,

According to this discrepancy, a corrective action has been initiated by Delastek.

The main reason is that we have requested another label B57879 (asked by Céline Audet), as the part would be scrap. Finally, this part has been repaired and was conform, but another part was manufactured, with the label B57879 ; this is the reason why we have two parts with the same serial number.

To correct this situation, we will change the type of product in our manufacturing system for a product with serial number to avoid that the same serial number is used 2 times. This change will be effective from june 11, 2010.

If you have any questions, feel free to contact me,

Regards,

**Nancy Carignan**

Département Qualité / Quality Departement

### **DELASTEK Inc.**

2699, 5e Avenue

Local 14, C.P. 123

Grand-Mère, Québec

G9T 5K7

Tel : 819-533-5788 # 264

Fax : 819-533-3494

[ncarignan@delastek.com](mailto:ncarignan@delastek.com)

---

**De :** Chantal Lavoie [mailto:clavoie@dartaero.com]

**Envoyé :** 2 juin 2010 12:51

**À :** 'Jocelyne Laurin'

**Cc :** ncarignan@delastek.com

**Objet :** RE: PO 11710

Hi Jocelyne,

Any news on the reason of the mix up for the label.

Thanks

Chantal

---

**From:** Jocelyne Laurin [mailto:jlaurin@delastek.com]

**Sent:** June 1, 2010 1:26 PM

**To:** 'Chantal Lavoie'

**Subject:** PO 11710

Hello Chantal,

I transferred you email to Nancy Carignan in QA [ncarignan@delastek.com](mailto:ncarignan@delastek.com) She should answer you shortly.

Thank you

6/03/10

*Jocelyne Laurin*

Agente Service à la clientèle/Customer Service Agent  
DELASTEK INC.  
[jlaurin@delastek.com](mailto:jlaurin@delastek.com)

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**De :** Chantal Lavoie [<mailto:clavoie@dartaero.com>]

**Envoyé :** 31 mai 2010 14:18

**À :** 'Jocelyne Laurin'

**Objet :** PO 11710

Hi Jocelyne,

We have rec'd D2445 on May 27, 2010, on the inside label it was the same batch # as the previous one B57879 what would be the cause of that please explain. I add only send 4 label for that p/o And one more after for a problem that you add in manufacturing them.

Thanks

Chantal

6/03/10

## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
		D2143	HINGE DOUBLER
		D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
		D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
		D2585	LATCH CLAMP
		D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
		D2857-1	LOWER HINGE BRACKET
		D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
		AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
		MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries